

6059-C Nitro Fuzer Welding Cart - Quick Start Guide

Initial Setup:



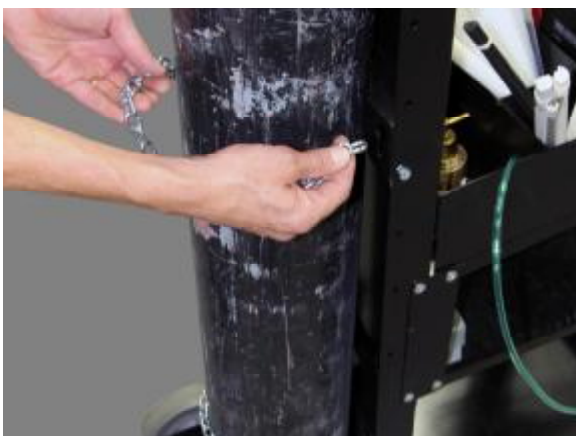
1. Unbox cart and remove accessories from box. Find the hot air welder and airless welder tips and screw them into the heating elements.



2. Install your shop's quick disconnect plug into the bottom inlet port of the cart's air manifold.



3. A short whip hose may be attached at the front of the air manifold if desired to power your die grinder and sander.



4. Install nitrogen tank (argon or argon/CO2 may also be used). Install included safety chains around tank. Adjust height of top tank cradle if necessary.



5. Screw the nitrogen regulator into the tank. Do NOT use teflon tape. Tighten securely.

Initial Setup:



1. Connect clean, dry, oil-free shop air to air inlet. Supply pressure should be set between 60-120 psi.



2. Set inlet pressure regulator on back of the welder to 15-20 psi.



3. Adjust fine flow control on the air (left) side so the flow meter reads 12 LPM. You should feel air coming from the torch.



4. Adjust hot air temperature control to Level 1 to prevent any current flow to heating element.



5. Plug in and turn on power strip. Turn hot air power switch on. Verify that the yellow light on the "air" side and the green "pressure safe" lights are glowing.



6. To turn on the nitrogen, back out the pressure screw on the nitrogen tank regulator to prevent overpressure from damaging the tank regulator or downstream components.



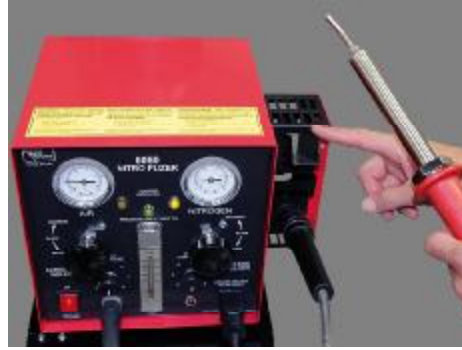
7. Crack open nitrogen tank valve slowly. Confirm that the tank gauge needle shows pressure in the tank.



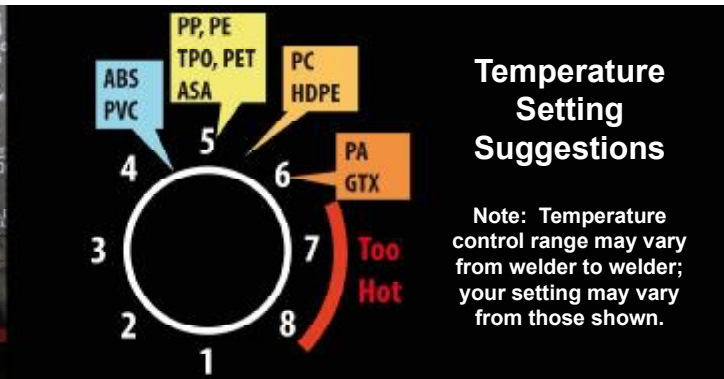
8. Turn pressure screw clockwise until the outlet side gauge shows 15 psi.



9. Remove torch from the holster to switch to nitrogen. Adjust the pressure on the nitrogen (right) side so the flow meter reads 12 LPM. You should feel nitrogen gas coming from the torch.



10. Switch the air selector back and forth between air and nitrogen, making sure that the yellow lights indicate which side is flowing, that the green pressure safe light is glowing on both sides, and that you have flow from the torch on both sides. Leave on air at all times except when you're actually welding.



11. Turn the temperature control dial to the proper level for the plastic you are working with. Let the welder warm up for five minutes before use.



12. Do NOT leave on heat level 7 or 8 for any length of time because you will overheat the element! These settings are appropriate for higher airflow settings and thicker plastics., NOT for thin plastics like used for most automotive parts.



13. Watch the instructional DVD to learn how to use the plastic welder. Practice on a scrap bumper first before you do any actual repairs.

CAUTION - you must use CLEAN, DRY, OIL-FREE air for the hot air welder. Water and/or oil inside the heating element will drastically shorten its life span.

CAUTION - you must ALWAYS maintain airflow through the welder while it is hot or the power is on. Failure to do so will burn out your heating element. Urethane Supply Company DOES NOT WARRANT the heating element because its life is completely under YOUR control.

Shutdown Procedure:

The shutdown procedure is **VERY IMPORTANT** for maximizing the life of your heating element. You **MUST** shut down power to the unit first, then let clean, dry, oil-free air flow until the heating element is completely cool. **You are in control of your heating element's life...** Urethane Supply Company cannot warrant the heating elements for this reason.



1. Place torch in the upper holster and turn the air temperature control to Level 1 to shut down the power to the heating element. Turn up the air-flow to >25 LPM to speed the cooling process.



2. Close the nitrogen tank valve. This will prevent any downstream bleed-off from draining the tank while the welder is off.



3. Let the air flow for 10 minutes or until the air flowing from the welding tip is completely cold.



4. Shut off main power and stop airflow by unscrewing the air regulator knob until loose. Disconnect air supply and unplug from the wall.



Contact info@urethanesupply.com or call 800-633-3047 with any other technical questions. You may also visit www.urethanesupply.com or become a fan on our Facebook or LinkedIn page to get the latest information.